



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBST1007-13
Job Sheet 171042



Part No: RBST1007-13

Job Qty: 1 ea

Part Name: Secondary Seat



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/26/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBST1000 REV.7 IPP REV:A 18.01.25 NEW ISSUE JFC VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/30/18	0.00	0.00	Start Up Machining-4		18-2-20
110	CNC Lathe	1 pcs		1/31/18	0.00	0.25	MORI SL-154		18
120	QC	1 pcs		1/31/18	0.00	0.00	QC2		18
130	QC	1 pcs		1/31/18	0.00	0.00	QC8		18-02-26
150	Outsource	1 pcs		1/31/18	0.00	0.00	Outsource12		AT 18/03/19
160	Packaging	1 pcs		1/31/18	0.00	0.00	Packaging2		AT 18/03/19
170	QC	1 pcs		1/31/18	0.00	0.00	QC6		38
180	Packaging	1 pcs		1/31/18	0.00	0.00	Packaging3		38
210	QC21-SA	1 Ea		1/31/18	0.00	0.00			GA 137

Part Op 110 - 1-Machine as per FOLIO FB758. FOLIO REV: _____ DWG REV: _____ 2-Deburr 3-Engrave P/N

Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG.

150 - -Issue P/O to Groupe Altech; PO 039186 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.375	MT-4140 QT-R1.375	.1000 ft (.1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.375	0	0	0

Part Specifications

Specifications cou



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S043764



Part: RBST1007-13

Job No: 171042

Serial No/Batch: S043764

Revision: RBST1000

Inspector:

Date: 02/20/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

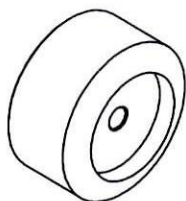
QA Closed: _____ Date: _____

Work Order update only ☐

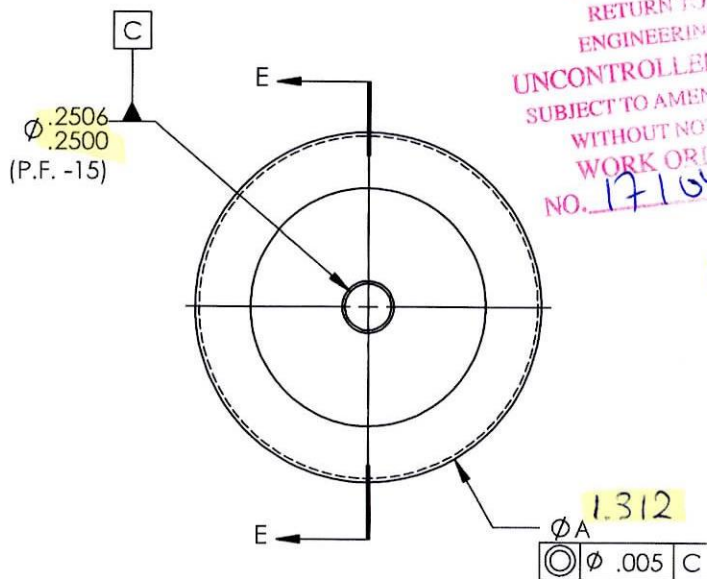
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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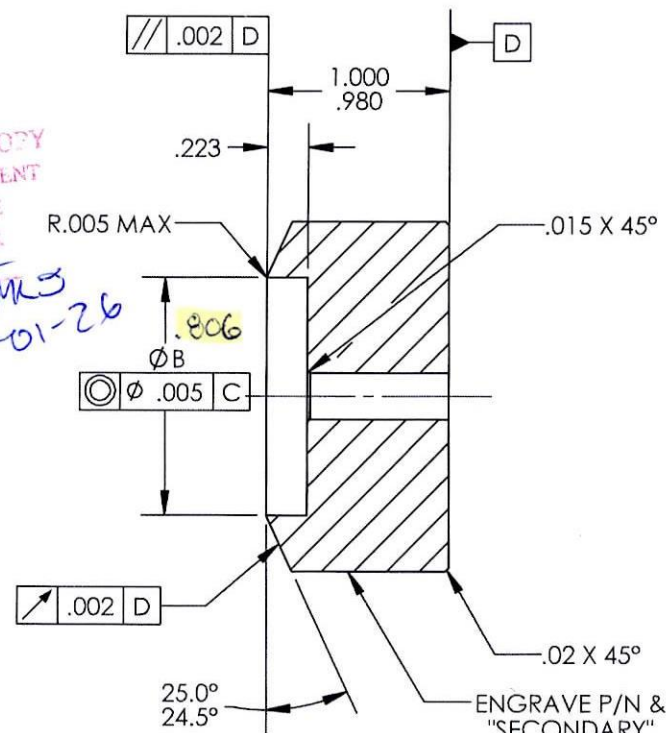
REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
7	15-0033	-13 CH'D MATL FROM 4140 Q&T TO 4140/4142. ADDED HEAT TREAT RC 28-34. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. CH'D DIM WAS REAM Ø.249 P.F. -15 IS LIMITS Ø.2500-.2506. IMPROVED GD&T.	2/17/2015	DPD	SM



TOOL NUMBER	ØA +.000 -.030	ØB +.000 -.005
RBST1000		.500
RBST1001		.563
RBST1002	1.062	.586
RBST1003		.625
RBST1004		.660
RBST1005		.712
RBST1006	1.312	.806
RBST1007		.837
RBST1008		.875
RBST1009		.900
RBST1010		.968
RBST1011	1.500	1.025
RBST1012		1.062
RBST1013		1.087
RBST1014		1.250
RBST1015	1.875	1.312
RBST1016		1.437
RBST1017		1.500
RBST1018	2.062	1.625
RBST1019		2.000
RBST1020	2.437	2.000



SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 171042
MKJ
18-01-26



SECTION E-E

NOTE:
BREAK ALL SHARP CORNERS .015 - .030.

DART AEROSPACE	
TITLE RBST1000 THRU 1020 DRILL PRESS TRI-ROLLER SWAGING TOOL	
DWG NO. SEE TABLE-13	REV 7
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 28-34	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	SEE TABLE
SCALE 1:1	DATE 1/4/2008 SHEET 8 OF 9

(-13)

SECONDARY
SEAT

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					



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PURCHASE ORDER PO039186

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	170063	RB412WA-CR&O-3-62-2A-1-2	required Blade Bolt Segments Removal / Installation Workaid -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	3/16/18	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00
7	171450	RBW6405G02331-3G-05	Puller -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	3/16/18	2 pcs	0 pcs	2 pcs	\$6.00/pcs	\$12.00
8	171449	RBW6405G02331-3G-07	Pin -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	3/16/18	9 pcs	0 pcs	9 pcs	\$6.00/pcs	\$54.00
9	172466	RBE350A94-3700-C-01	Tube -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/16/18	9 pcs	0 pcs	9 pcs	\$1.80/pcs	\$16.20
10	171042	RBST1007-13	Secondary Seat -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/16/18	4 pcs	0 pcs	4 pcs	\$0.95/pcs	\$3.80
11	171709	RBT18603-1	Handle -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/16/18	5 pcs	0 pcs	5 pcs	\$2.25/pcs	\$11.25
12	171712	RBT18603-7	Foot -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is	Firmed	3/16/18	4 pcs	0 pcs	4 pcs	\$0.89/pcs	\$3.56

DAS
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Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

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Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
16-Mar-2018		Celine Schreindorfer		PO039186				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	A venir/ Back Order
2	RBE2-10-1-01 Rev.	RBE2-10-1-01 01 -BLACK OXIDE ON SST MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4	BLACK-OXIDE CH	6	6	0	0	0
3	RBE350A93-3303-02-1 Rev.	RBE350A93-3303-02-1 01 -BLACK OXIDE FINISH M MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
4	RBE350A93-3303-02-3 Rev.	RBE350A93-3303-02-3 01 -BLACK OXIDE FINISH ON SST MIL-C-13942C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
5	RBE350A93-3317-20 Rev.	RBE350A93-3317-20 01 -BLACK OXIDE FINISH ON SST MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
6	RB412WA-CR&O-3-62-2A-1-2 Rev.	RB412WA-CR&O-3-62-2A-1-2 ASTM B633 TYPE 1 SC2	ZINC CH	✓ 4	4	0	0	0
7	RBW6405G02331-3G-05 Rev.	RBW6405G02331-3G-05 ON SST MIL--C-13924C, CLASS 1	ZINC CH	✓ 2	2	0	0	0
8	RBW6405G02331-3G-07 Rev.	RBW6405G02331-3G-07 ASTM B633 TYPE 1 SC2	ZINC CH	✓ 9	9	0	0	0
10	RBST1007-13 Rev.	RBST1007-13 01 -BLACK OXIDE ON SST MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
11	RBT18603-01 Rev.	RBT18603-01 01 -BLACK OXIDE ON SST MIL-DTL-13924C CLASS 1	BLACK-OXIDE CH	5	5	0	0	0
12	RBT18603-07 Rev.	RBT18603-07 01 -BLACK OXIDE ON SST MIL-DTL-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
13	RBST1007-11 Rev.	RBST1007-11 01 -BLACK OXIDE ON SST MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0

9. RBE350A94-3700-C-01

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Certificat de Conformité / Certificate of Compliance



Bon de Livraison / Packing Slip

007318- 1

Tel.: 613-632-5200 Fax: 613-632-5201

BUYER:

Notes Additionnelles / Additional Notes

Received By

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements. Our financial and legal responsibility will not be higher than the amount of invoice.